



Product Data

Q-41-20 Robofoam Mastic Sealant

Issue Date: 11/03/2010

Purpose

This is a foamed-in-place gasketing sealant combining the best qualities of both closed cell foam gaskets and elastomeric mastics. It has high adhesion and moderate surface tack and combines the low force to compress and high resiliency of foam with the water resistance and webbing characteristics of a good butyl sealant.

Composition

This material is made of butyl and E.P.D.M. rubbers and proprietary co-polymer. It contains some process aids, antioxidants, fungicides, and adhesion promoters.

Detail

This product was developed for snap locked seams in standing seam roofs. It can also be used quite effectively in crimped seams. It is very cost effective foam-in-place gasket that is high adhesion and thus is particularly well suited to the snap seam that lacks protection. This product is usually applied through fixed or flexible automation in a controlled factory environment. It can be foamed to a density of 20lb/cubic ft. When using this material on snap seams, all clips and fasteners must also be sealed with Q-41-20.

Application

This is intended for use in factory environment with a hot melt unit. The application should be made with a Nordson FoamMelt© unit (or similar equipment) at a setting of 325°-350°F (163°-177°C) and with the gas demand for the nitrogen cylinder should be set at 40 psi.

Clean Up/ Precautions

The material can be cleaned from tools and equipment with a light application of mineral spirits.

Prolonged exposure to temperature exceeding 375°F will result in a thermal breakdown of the compound and greatly reduce its physical characteristics and performance.

Packaging

55gal. fiber drum with a 22" dia. rim. Also standard 4" x 6" x 8" blocks.
(special/alternative configurations are possible. Contact customer service for information)

Freight Classification

Test Data

Color: Amber

Odor: None, after cure

Melt point: Ball & Ring, 300°F (149°C)

Tensile Strength: ASTM D412, Die "C" 65psi

Slump: 3/8" Bead @ 250°F (121°C) no slump or sag

Solids Content: 1 hour @ 350°F (177°C) 99.85% ASTM 771-74

Elongation:
0°F (-18°C) – 450% min.
77°F (25°C) – 900% min.

Plasticizer Migration: ASTM c772-74, No bleed or stain

Cold Temperature Flexibility: ASTM C765-73 – passes

Water Resistance: ASTM D1056, unfoamed – 0.0% foamed - .01%

Adhesive Tensile: ASTM D987-78-25psi min.

Specific Gravity: ASTM D71-78, .86 + .02 Wt./Gal, 7.2+2

Shelf and Service Life: 20 years min.

Force to Compress: As measured when one of cubic inch of 3/8" thick material is compressed to 3/16" thick material @ 2"/min
0°F(-18°C) – 60psi
77°F(25°C) – 30psi
120°F(49°C) – 15psi
Foamed at 50%

Aging Characteristics: ASTM D750-68 (1000hrs) on surface – slight haze

Heat Distribution: ASTM D816-55 – No sag

MBMA Water Damming Test: 5", Passes 5 water head simulated test.



Product Data

“NOIBN” (no red label required) Class 55, Item No. 149610 HMIS Rating: Health-0, Flammability-0, Reactivity-0.

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